

Date: Wednesday, 1/30/2008 7:53:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOP PANEL ASS'Y
 Job Number : 37060
 Estimate Number : 13034
 P.O. Number :
 This Issue : 1/30/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D36509
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3650 REV.B U/R
 Previous Run : 35714 Drawing Revision : B U/R
 Written By : W Material :
 Checked & Approved By : W Due Date : 2/5/2008 Qty: 2 Um: Each
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD

08-02-17
 POSITIVE
 RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.1071 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 105592 IB 8-2-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3650

Dwg Rev: U/R IB 8-2-1
 Prog Rev: U/R

2-Deburr if necessary IB 8-2-1

②

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-2-1



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/02/04 ②

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D3650

IB 08-02-13

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-9 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2D Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR: 37060		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/13	5	Old scrap	<i>RB</i> <i>08/03/13</i>	<i>Destroy</i> <i>Qty (X)</i>	<i>RB</i> <i>08/03/13</i>	<i>[Signature]</i> <i>08/03/14</i>	<i>RB</i> <i>08/03/14</i>	<i>[Signature]</i> <i>08/03/14</i>

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:53:10 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 37060

Part Number: D36509

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.03.14

08.03.14 (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: 00038103

08.03.14 21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08.03.18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.03.14

POSITIVE RECALL

EFFECTIVE 08.03.14 AUTH 1

RELEASED 08.03.18 DATE 08.03.18

Dart Aerospace Ltd

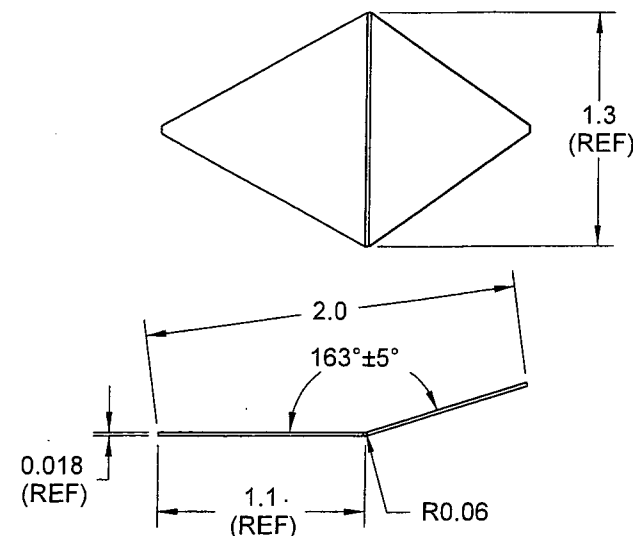
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

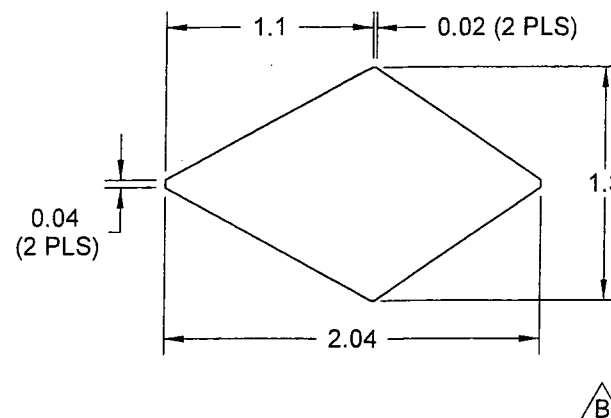
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

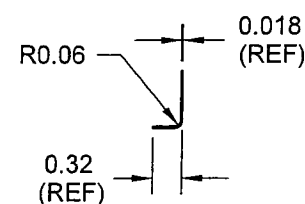
NOTE: Date & initial all entries



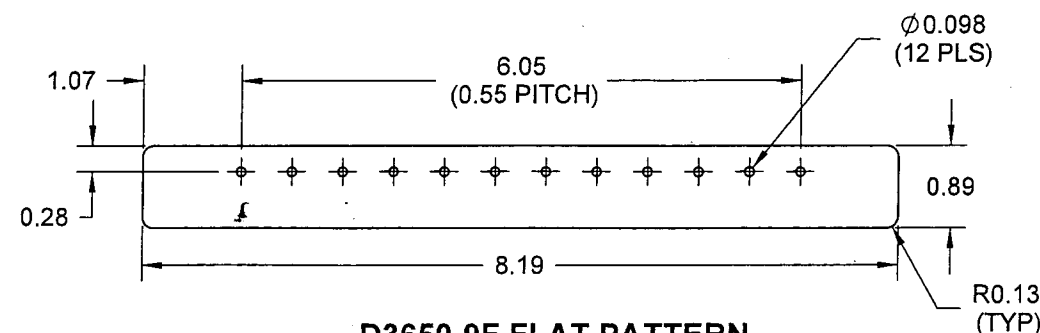
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



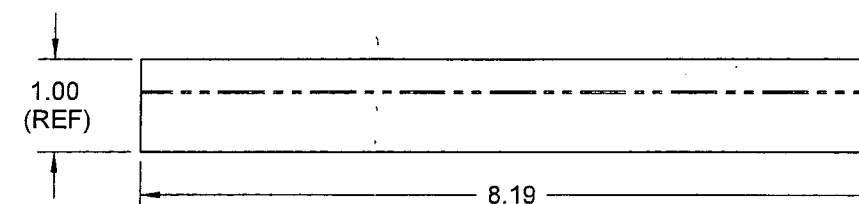
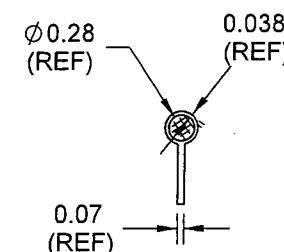
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-9F FLAT PATTERN



D3650-7-8.19 SEAL

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

PRELIMINARY ISSUE

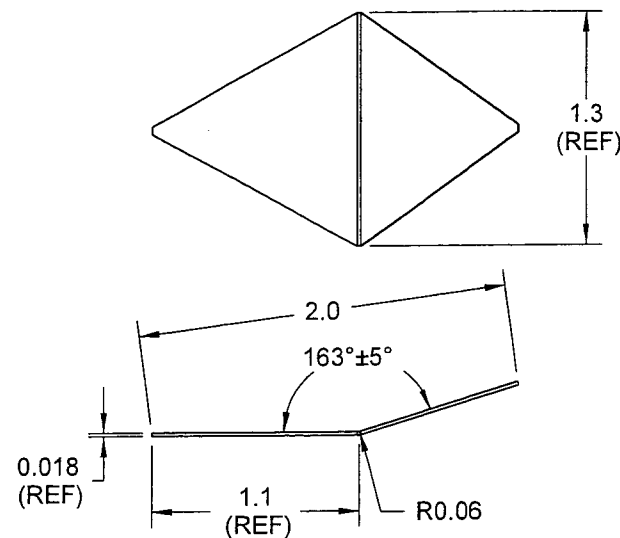
08.01.18

D3650-9 & D3650-11 NOTES:

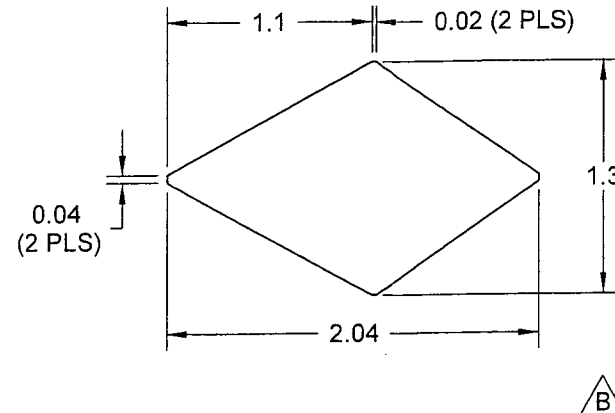
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO. D3650	REV. B
MFG. APPR.	LE	SHEET 9 OF 9	
APPROVED	LE	TITLE TOP PANEL ASSEMBLY	SCALE 1:2
DE APPR.			
DATE	08.01.07		

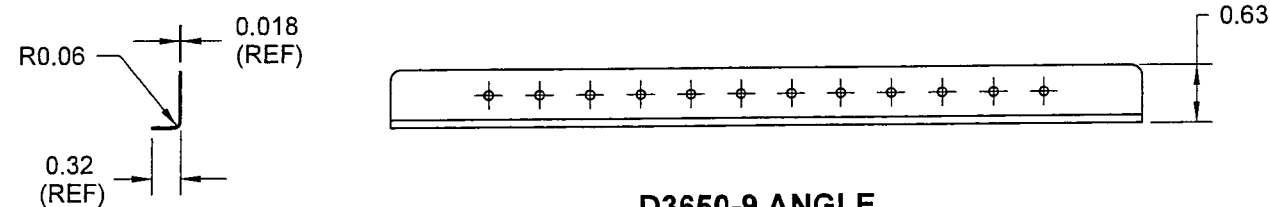
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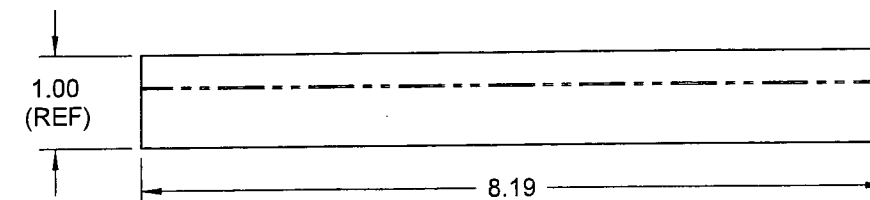
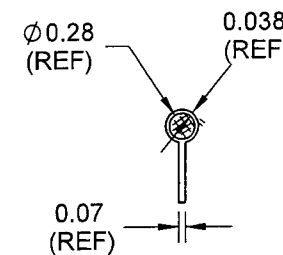
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



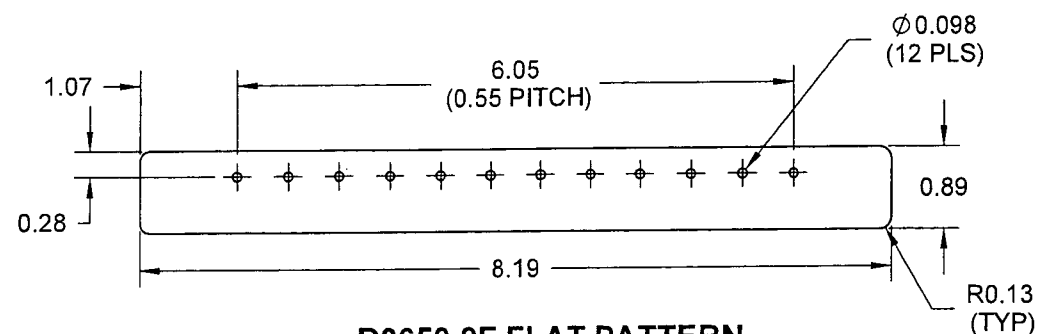
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

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POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: NONE
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- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

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PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:2
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	